

CLAIMS

1. A manufacturing method of a wet-type segmented friction material that has a core metal of a flat ring shape and a friction material substrate cut into a segment shape along the flat ring shape of the core metal, comprising the steps of:
 - 5 processing an area around a cut portion corresponding to the segment shape of the friction material substrate with a heat press compression forming;
cutting the cut portion of the friction material substrate into the segment shape after said processing step, thereby preparing segment pieces each having the segment shape; and
 - 10 joining by adhesion the segment pieces on one or both surfaces of the core metal along the flat ring shape.
2. A manufacturing method of a wet-type segmented friction material according to claim 1, in which the processing step with the heat press compression forming is
15 carried out on only two sides as two straight lines of the cut portion of the segment shape of the friction material substrate.
3. A manufacturing method of a wet-type segmented friction material according to claim 1, in which the processing step with the heat press compression forming is
20 carried out on all four sides of the cut portion of the segment shape of the friction material substrate.
4. A manufacturing method of a wet-type segmented friction material according to claim 1, in which the processing step with the heat press compression forming is
25 carried out under a heating temperature of about 100°C to about 350°C.

5. A manufacturing method of a wet-type segmented friction material according to claim 1, in which the processing step with the heat press compression forming is carried out so that a thickness of the friction material substrate after the heat press compression forming becomes within a range of about 20% to about 95% of a thickness of the friction material substrate in the wet-type segmented friction material as a finished product.

6. A manufacturing method of a wet-type segmented friction material according to claim 1, in which the processing step with the heat press compression forming is carried out so that a thickness of the friction material substrate after the heat press compression forming becomes substantially the same as a thickness of the friction material substrate in the wet-type segmented friction material as a finished product.

7. A manufacturing method of a wet-type segmented friction material according to claim 1, in which the processing step with the heat press compression forming is carried out so that a width of a compressed portion of the friction material substrate after the heat press compression forming becomes about 0.1mm to about 2.0mm when the friction material substrate is cut into the segment shape.

8. A wet-type segmented friction material comprising:
a core metal of a flat ring shape; and
a friction material substrate cut into a segment shape along the flat ring shape of the core metal, thereby preparing segment pieces each having the segment

shape, the segment pieces being joined by adhesion on one or both surfaces of the core metal along the flat ring shape, an area around a cut portion corresponding to the segment shape of the friction material substrate being pressed and compressed at two side as two straight lines of the cut portion or at all four sides of the cut
5 portion when the friction material substrate is cut into the segment shape.

9. A wet-type segmented friction material comprising:

a core metal of a flat ring shape: and

a friction material substrate cut into a segment shape along the flat ring
10 shape of the core metal, thereby preparing segment pieces each having the segment shape, the segment pieces being joined by adhesion on one or both surfaces of the core metal along the flat ring shape, a gap as an oil groove being formed between adjacent segment pieces joined on the surface of the core metal, a width at an outer peripheral opening of the gap being larger than a width at an inner peripheral
15 opening of the gap.

10. A wet-type segmented friction material according to claim 9, in which the width at the outer peripheral opening of the gap is about one and a half times as large as the width at the inner peripheral opening of the gap.

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11. A wet-type segmented friction material according to claim 9, in which the width at the outer peripheral opening of the gap is about twice to about three times as large as the width at the inner peripheral opening of the gap.

25 12. A wet-type segmented friction material according to claim 9, in which the

segment piece has a round shape formed at each of four corners.

13. A wet-type segmented friction material according to claim 9, in which the segment piece has a chamfered shape formed at each of four corners.

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14. A wet-type segmented friction material according to claim 9, in which the gap as the oil groove between the adjacent segment pieces has substantially a V-shape.